

Dart Aerospace Ltd

W/O: 73982		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2435 PAR #: N/A Fault Category: Machine NCR: Yes No DQA: Date: 11.11.03
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Date: 11/11/04

NCR: 11.948		WORK ORDER NON-CONFORMANCE (NCR) Note: OB						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/10/26	#110	Flour thickness measures 0.598" should be 0.625" and 0.203" should be 0.250" and 0.203 Dim .932" is mean		SCRAP + DESTROY ON THE BASIS THAT THE MAXIMUM ALLOWABLE WEAR IS CONSIDERABLY	K.K. 11/10/27	B.A. 11/10/27		8 11/10/26
		0.680". AND Dim .325" is .0.330". All in Pass and to the Right side (Dim 10.362). R.L. insert was not seated correctly. LOP.	11.10.26	REDUCED. Qty 1	K.K. 11/10/27	B.A. 11/10/27	11.10.26 11/10/27	8 11/10/26
		(Dy is clean, Pulio is clean tool is good)				B.A. 11/10/27		8 11/10/26

NOTE: Date & initial all entries

Work Order ID 73982

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Item ID:	D2435	Accept		Setup	Start	
Revision ID:						
Item Name:	Bearpaw, 206				Stop	
Start Date:	9/20/2011	Start Qty:	12.00			
Required Date:	10/4/2011	Req'd Qty:	12.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00		11/10/27		11	6		
Quality Control									
151	Identify as per dwg & Stock Location:	0.00							
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

PPP 73979

SI 11/10/27

SP 11-10-31

11/10/31
MF
11-10-31

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Picklist Print

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Work Order ID: 73982

Parent Item: D2435

Parent Item Name: Bearpaw, 206




Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 12.00

Required Qty: 12.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 		Purchased	No			120	sf	623.6200	3.2	38.4			
UHMW 1" Black													



B11-10-3

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT018	383.62	
117321	76.6	
117738	124.3	
117819	99.3	
118257	83.42	
ST	240	
118814	240	

118814

⑤

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DART AEROSPACE LTD		Work Order: 7382
Description: Bearpaw		Part Number: D2435
Inspection Dwg: D2435	Rev: E1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓		Vern FK04	
B	5.500	+/-0.030	5.498	✓		"	
C	0.200	+/-0.030	0.192	✓		FK06 Depth gauge	
D	R0.250	+/-0.030	0.25	✓		rad gauge	
E	0.250	+/-0.010	0.248	✓		Vern FK04	
F	0.625	+/-0.030	0.635	✓		"	
G	0.25 x 45°	+/-0.030	0.25 x 45°	✓		"	
H	0.375	+/-0.010	0.380	✓		"	
I	19.000	+/-0.030	19.000	✓		Tape FK05	
J	0.950	+0.030/-0.010	0.946	✓		Vern FK04	
K	Ø0.260	+0.005/-0.000	0.260	✓		"	
L	Ø0.930	+/-0.030	0.930	✓		"	
M	0.30	+0.030/-0.000	0.311	✓		FK06 Depth gauge	
N	0.375	+/-0.030	0.383	✓		Vern FK04	
O	7.375	+/-0.030	7.375	✓		CNC-2 Vern	
P	4.250	+/-0.010	4.255	✓		FK04 Vern	
Q	2.000	+/-0.030	1.993	✓		"	
R	9.000	+/-0.010	9.000	✓		CNC-2 Vern	
S	15.750	+/-0.030	15.750	✓		Tape FK05	

Measured by: IK-	Audited by: GA	Prototype Approval: N/A
Date: 11/10/26	Date: 11/10/27	Date:

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	

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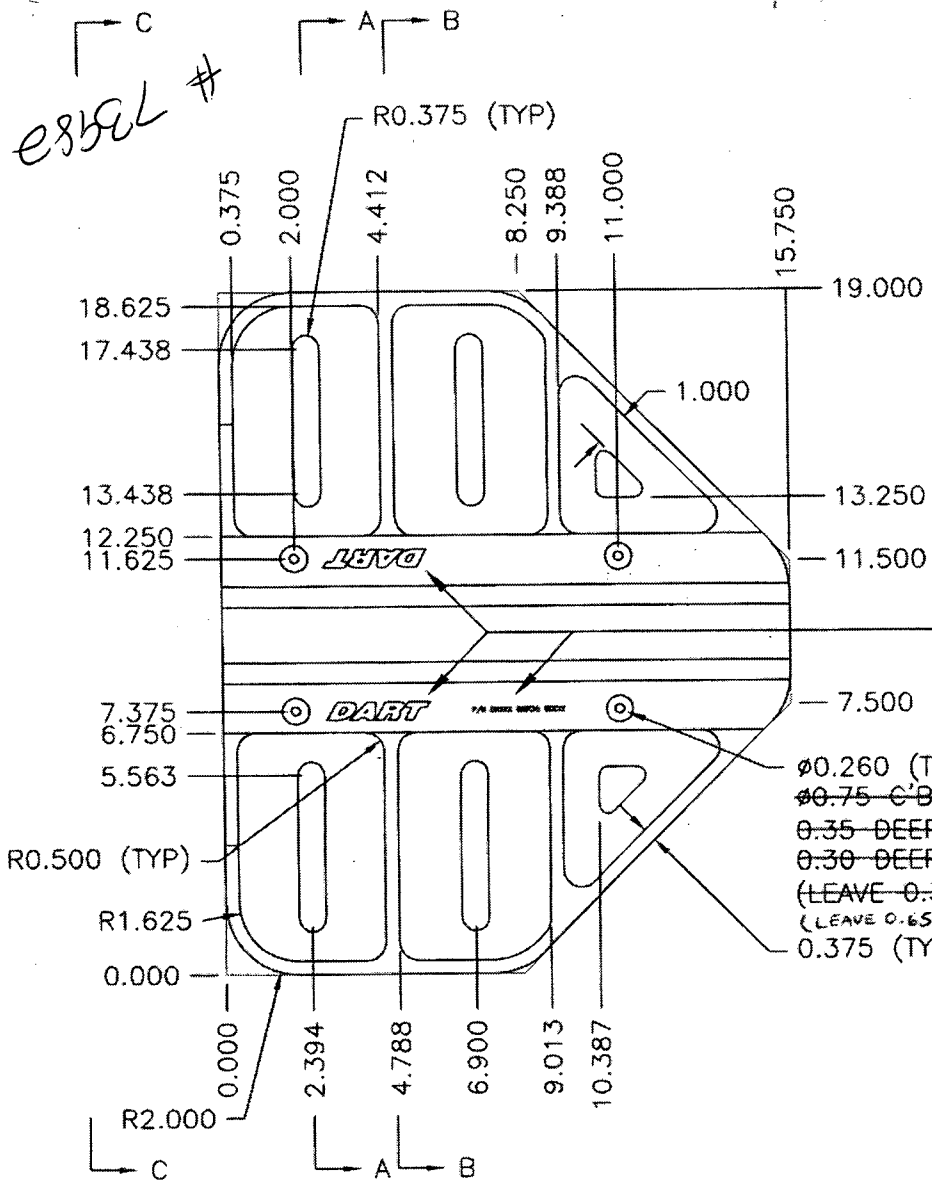
E1 02.12.17 $\phi 0.93$ WAS $\phi 0.75$ ~~RE~~

RELEASED
98.06.17 KE



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2435	SHEET 1 OF 2
DATE 98.05.19	TITLE BEARPAW	SCALE 1:5	
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

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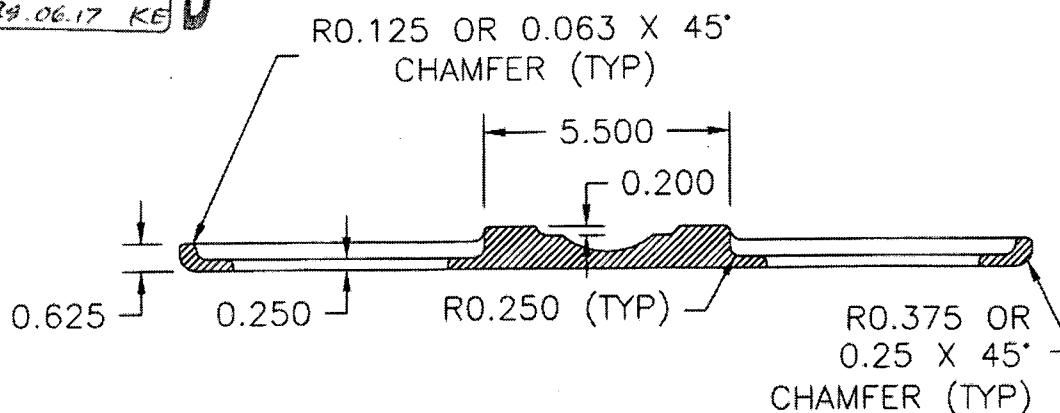
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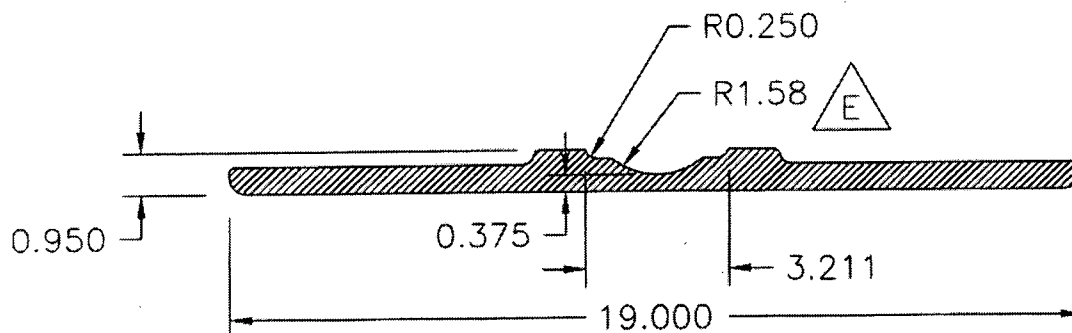


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DM</i>	APPROVED <i>KE</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE

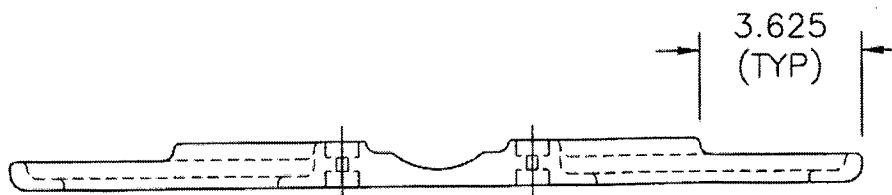


SECTION A-A



SECTION B-B

#73980



SECTION C-C

Dart Aerospace Ltd

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